

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001379**Date Inspected:** 22-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock-Up**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector, M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.), on Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

89-meter Mock-Up, Z. P. M. C. Welders, Li Zhaoqian—048810, Li Mengqian—054460, and Lei Lichao—053619, were welding on weld number MUB-MA21-D/5-4A, the interior side of the Skin C to D joint.

WPS-B-T-2232-U4b-F was being utilized. The QA Inspector checked the welding parameters and measured them at 304 amps, 31.3 volts, and 296 amps, 30.8 volts, respectively, as (2) two welding machines were being used between the (3) three welders. Z. P. M. C., Quality Control (QC) personnel, checked the preheat and inner pass temperatures, while the QA Inspector was checking the WPS parameters, and found it to be low, and stopped the welders, while additional heaters were placed on Skin C.

Summary of Conversations:

The QA Inspector spoke with QC Inspector Xu Le Feng, thru Interpreter Ken Jiadi, about the preheat at the above mentioned weld number, in regards to the importance of checking the preheat often, but especially so in cold weather.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
